

Date: Monday, 5/15/2006 11:11:50 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: BUSHING		
Job Number	: 27108					
Estimate Number	: 10725					
P.O. Number	: N/A			Part Number	: D2652	
This Issue	5/15/2006	S.O. No.	: N/A	Drawing Number	: D2652 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	5/15/2006	Type	: MACHINED PARTS	Drawing Revision	: A	
Previous Run	: 26644			Material	: N/A	
Written By	: <i>See J comment below</i>			Due Date	5/30/2006	Qty: 200 Um: Each
Checked & Approved By	: <i>dk 06.05.15 K</i>			Comment	: Est Rev:B 02.06.13 Now machined in house.	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0500	303 Round Bar 0.500"	
		<i>Comment: Qty.: 0.0578 f(s)/Unit Total : 11.5500 f(s) Material:303 ss .500" Round Bar (M303R0500) Batch: M 19488</i>	<i>MS 06/06/11 200</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		<i>Comment: HARDINGE CNC LATHE SMALL</i>	<i>MS 06/06/11 200</i>
		<i>1-Turn as per Folio FA250 & Dwg D2652</i>	
		<i>2-Deburr</i>	<i>MS 06/06/11 200</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</i>	<i>MS 06/06/11 200</i>
4.0	QC8	SECOND CHECK	
		<i>Comment: SECOND CHECK</i>	<i>MS 06/06/11 200</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		<i>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: story - <i>Loc 12/6 (200)</i></i>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

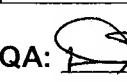
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 5/15/2006 11:11:50 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27108

Part Number: D2652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

200
D 06/06/13

Job Completion



U 06/06/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD Work Order: 27108

Description: Busing Part Number: DZ602Z

Inspection Dwg: D26

Rev: A

Part Number: U2632

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

100

First Article Prototype

110

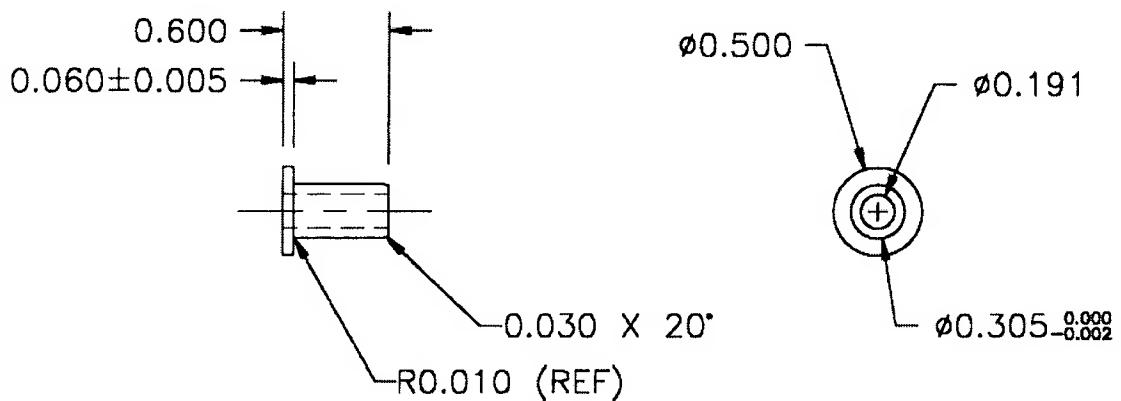
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	.600	✓			
0.060	+/-0.005	.060	✓			
Ø0.305	-0.002/+0.000	.304	✓			
Ø0.191	+0.005/-0.000	.192	✓			
Ø0.500	+/-0.010	.500	✓			
0.030 x 20°	+/-0.010	.030	✓			
R0.010	+0.010/-0.000	.015	✓			

Measured by:	MS	Audited by:	Any
Date:	06/06/11	Date:	06/06/11
Rev	Date	Change	Prototype Approval: N/A
A	03.12.12	New Issue	Revised by: KJ/RF Approved: <u> </u>



DESIGN <i>DIMY</i>	DRAWN BY <i>DIMY</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>BS</i>	APPROVED <i>BS</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *27108*